

8

Date: Thursday, 2/7/2008 10:51:40 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STROBE POWER SUPPLY RELOCATION
 Job Number : 37267
 Estimate Number : 12033
 P.O. Number :
 This Issue : 2/7/2008 S.O. No. :
 Prsht Rev. : NC Part Number : DSI9279011
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3246 REV A1
 Previous Run : 37028 Project Number : N/A
 Material :
 Due Date : 2/22/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. B 04.06.16 Changed rivet & added c'sink KJ/RF
 Est Rev:C Now On Waterjet 06-06-22 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue Traveler

Note: To be made in multiples of 5

Photocopy bluefile and create labels as per PPP DSI 9279-011 CHG001

5 08/04/03 08/02/07

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3246041 Mounting Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Mounting Bracket

Pick: Packing Kit

(Note: D3246-1 is on BOM as material from Step 3)

40

Qty Part Number Description Batch

1 D3246-041 Mounting Bracket Assy

036939 (1x)

37268 (7x) 54

4.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick : Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

M106552

8/4/13 50 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STROBE POWER SUPPLY RELOCATION

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS27039107

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch
4 MS27039-1-07 Screw

M18057

8/4/3

SCD

(SX)

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/08 (SX)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI 9279-011

Rev A

LOC 20

SP

8/4/3

(SX)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08 (SX)

Job Completion



U 08/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

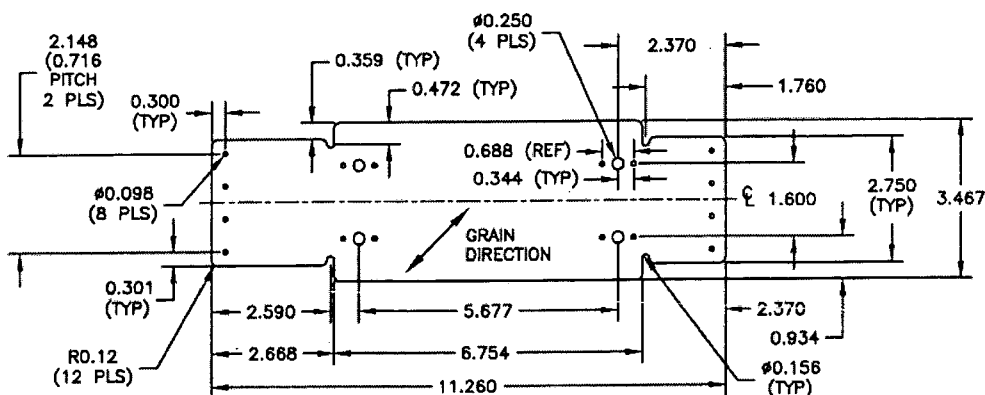
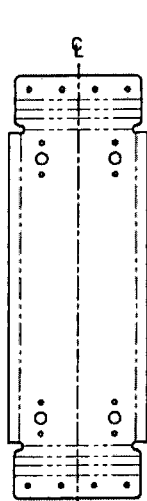
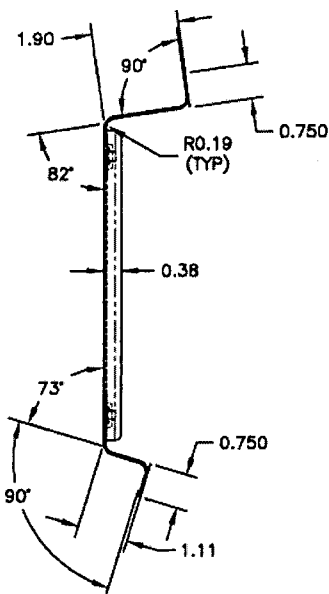
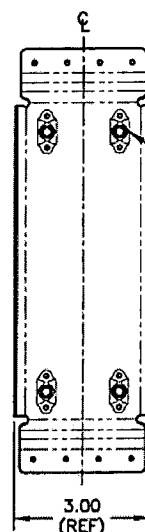
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
A1	04.06.16	CHANGE RIVET; ADDED C'SINK	

RELEASED
04.05.07**D3246-1 FLAT PATTERN****D3246-1 BEND DETAIL****D3246-041 ASSEMBLY**

MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK $\phi 0.185 \times 100^\circ$
MS20426AD3-3 RIVET (2)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37267

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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